

Work Order ID 62171

Monday, September 20, 2010 10:17:21 AM



Page 1

Item ID: D3686-041

Accept



Setup Start



Revision ID:

Stop



Item Name: MONOPOD ASSEMBLY

Start Date: 9/20/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/1/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start

Approvals: Process Plan: MF Date: 10-9-20

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3686

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

GB 10/09/20 (V)

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3686

2-Assemble D3693-1 & D3691-1 & D3693-3 & D3688-7 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3686

***Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3686

GB 10/09/20 (V)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

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Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 1390

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/22

MF

10-9-22

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Picklist Print

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Work Order ID: 62171

Parent Item: D3686-041

Parent Item Name: MONOPOD ASSEMBLY




Start Date: 9/20/2010

Required Date: 10/1/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3688-7  STUD		Manufactured	No			110	Each	8.0000	1	1		EP 10/09/20	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST081			8						
				44686			1						
				50931			7						
D3689-1  SLEEVE		Manufactured	No			110	Each	13.0000	1	1		EP 10/09/20	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST082			13						
				56335			1						
				58634			12						
D3691-1  STUD		Manufactured	No			110	Each	15.0000	1	1		EP 10/09/20	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST082			15						
				58631			15						

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Parent Item: D3686-041

Parent Item Name: MONOPOD ASSEMBLY

Start Date: 9/20/2010

Required Date: 10/1/2010

Start Qty: 1.00

Required Qty: 1.00

D3692-1

Manufactured No

110

Each

349.0000

4

4



SPACER

Location

Loc Qty

Loc Code

ST082

349

51467

349

D3692-3

Manufactured No

110

Each

45.0000

4

4



SPACER

Location

Loc Qty

Loc Code

ST082

45

44690

45

D3693-1

Manufactured No

110

Each

40.0000

1

1



Rod End Bearing

Location

Loc Qty

Loc Code

ST082

40

50734

40

D3693-3

Manufactured No

110

Each

6.0000

1

1



Rod End Bearing

Location

Loc Qty

Loc Code

ST082

6

50723

6

AN3C10A

Purchased No

110

Each

36.0000

2

2



Bolt

Location

Loc Qty

Loc Code

ST351

36

105940

16

112489

20

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Shop Packet Print

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Start Date: 9/20/2010

Required Date: 10/1/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C12A	Purchased	No	110	Each	86.0000	2	2	<i>E/S 10/09/20</i>
								
Bolts								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST351	86				
			112314	8				
			114761	11				
			115392	47			2	
			115594	20				
MS21043-3	Purchased	No	110	Each	2,643.000	4	4	<i>E/S 10/09/20</i>
								
Nut								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FG	76				
			103691	76				
			ST301	2567				
			109147	4				
			111383	46				
			112314	2517			4	
NAS509L12C	Purchased	No	110	Each	51.0000	1	1	<i>E/S 10/09/20</i>
								
Nuts								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST280	51				
			112314	41			1	
			112828	10				

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 9/20/2010

Required Date: 10/1/2010

Start Qty: 1.00

Required Qty: 1.00

NAS509-12C

Purchased

No

110

Each

46.0000

1

1



EP 10/05/20

Nuts

Location

Loc Qty

Loc Code

ST280

46

112453

46

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

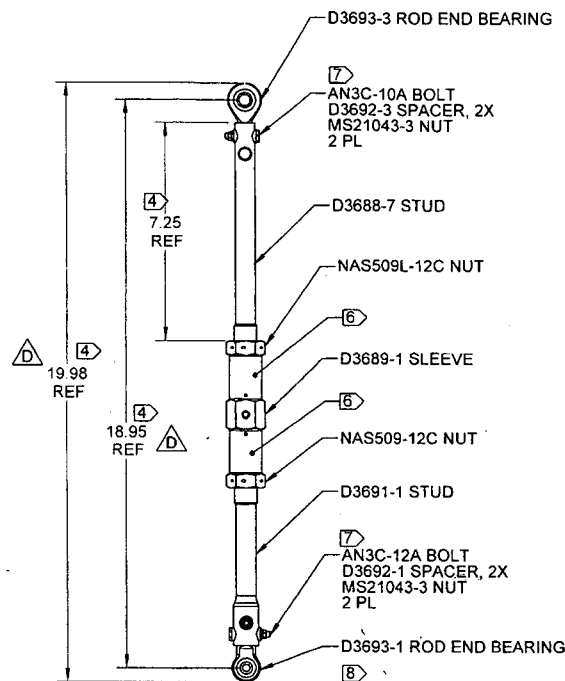
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ITEM	QTY .041	PART NUMBER	DESCRIPTION
1	X	D3686-041	MONOPOD ASSEMBLY
2	1	D3688-7	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	4	D3692-3	SPACER
7	1	D3693-1	ROD END BEARING
8	1	D3693-3	ROD END BEARING
9	2	AN3C-10A	BOLT
10	2	AN3C-12A	BOLT
11	4	MS21043-3	NUT
12	1	NAS509L-12C	NUT
13	1	NAS509-12C	NUT



D3686-041 MONOPOD ASSEMBLY

RELEASED
2010-03-15
JMS

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3686-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-7 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.0 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 & D3693-3 WITH D3688-7 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

D	19.98 WAS 20.10 (ZN C6-1); 18.95 WAS 19.07 (ZN C5-1)	RF	10.03.03
C	ROD END BEARINGS NOW ASSEMBLED USING SEALANT (ZN A8-1, B4-1)	RF	08.12.15
B	REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	RF	D3686	SHEET 1 OF 1
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MONOPOD ASSEMBLY	NTS
DATE	10.03.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL TEST TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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